

# Work Order ID 73907

Monday, September 19, 2011 8:12:23 AM



*Ship  
cap 29th*

Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 9/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/29/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *ME*

Date: *11-09-19*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3914

B

100



Weld per dwg A/R S.S. rod Batch: *M114649* 0.00

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3914 using DT9607A  
2- weld hinge (3) and Mounting brackets as per dwg D3914  
\*\*\*inspect before welding mesh\*\*\*  
3- tack weld mesh on basket as per dwg D3914  
\*\*\*make sure to place mesh correctly on lid, check with label plate before  
tacking mesh\*\*\*

*Sh PMB 11/09/22*

110



QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC

Memo

0.00

Quality Control

*QC 11.09.22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

*8/10/22*

Memo

0.00

130



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Memo

0.00

\*\*\* mask sides of fixture prior to powdercoat \*\*\*

Start Time:

Oven Temperature:

Finish Time:

*3:00*  
*3200F*  
*3:30*

*1X Ø M-11/09/22*

140



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch

0.00

Memo

0.00

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

\*\*\*Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label \*\*\*

*1 Ø M-11/09/23*

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Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

S ulo 123

160



Packaging

Packaging

Identify as per dwg & Stock Location: wlo

0.00

D1030-041 P B73 905

Memo

0.00

1 0 ulo 123

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

u/9/27

MF  
11-09-20

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# Picklist Print

Monday, September 19, 2011 8:12:20 AM

Page 1

Work Order ID: 73907

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 9/19/2011


Required Date: 9/29/2011

Start Qty: 1.00


Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
as per dwg revB DD 10.08.18 verified by:EC


IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581  Mounting Bracket		Manufactured	No			100	Each	36.0000	2	2		11/09/22	

Location	Loc Qty	Loc Code
WA	36	
69258	3	
69739	2	
70766	2	
73079	29	

D3914-1  Rib		Manufactured	No			100	Each	7.0000	2	2		11/09/22	
----------------------------------------------------------------------------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--

Location	Loc Qty	Loc Code
WA	3	
72087	1	
72656	2	
WA006	4	
73629	4	

D3914-7  Rib		Manufactured	No			100	Each	4.0000	2	2		11/09/22	
------------------------------------------------------------------------------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--

Location	Loc Qty	Loc Code
WA	4	
72794	4	

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 73907



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 9/19/2011

Required Date: 9/29/2011

Start Qty: 1.00

Required Qty: 1.00

D4016-3  
Hinge Half, Lid

Manufactured No

100 Each

13.0000

3 3



PMB 11/09/22

Location

Loc Qty

Loc Code

WA

12

72116

12

3

WA005

1

71941

1

D4018-5  
Rib

Manufactured No

100 Each

29.0000

9 9



PMB 11/09/22

Location

Loc Qty

Loc Code

WA

29

70758

5

72544

6

73631

18

6

3

D4020-5  
Mesh (350 Basket Long, Lid)

Manufactured No

100 Each

4.0000

1 1



PMB 11/09/22

Location

Loc Qty

Loc Code

WA

4

68234

1

69162

1

73540

2

1

D4021-3  
Data Plate

Manufactured No

100 Each

11.0000

1 1



PMB 11/09/22

Location

Loc Qty

Loc Code

WA

11

71943

5

73632

6

1

Monday, September 19, 2011 8:12:20 AM

Shop Packet Print

Page 2

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Monday, September 19, 2011 8:12:20 AM

Page 3

Work Order ID: 73907

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 9/19/2011

Required Date: 9/29/2011

Start Qty: 1.00

Required Qty: 1.00

D4035-041

Manufactured No

100

Each

3.0000

1

1



Lid Rib Assembly, Fwd (350 Basket)



PMB 11/09/22

Location

Loc Qty

Loc Code

WA

3

63720

0

72657

3

D4035-043

Manufactured No

100

Each

8.0000

1

1



Lid Rib Assembly, Aft (350 Basket)



PMB 11/09/22

Location

Loc Qty

Loc Code

WA

2

72542

2

WA006

6

73628

6

D2728-3

Manufactured No

140

Each

0.0000

1

1



Dart Logo label



M 115050

(v1) 11/09/22

Monday, September 19, 2011 8:12:20 AM

Shop Packet Print

Page 3

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**NOTE:** Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE

**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

# 73907

**RELEASED**  
10.08.17  
ECN 10-596

REV.	B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
REV.	A	NEW ISSUE	JPH	10.03.16
DESIGN		DESCRIPTION	BY	DATE
DRAWN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	SC	DRAWING NO.	REV. B	
MFG. APPR.	AS	D3914	SHEET 1 OF 4	
APPROVED	AS	TITLE	SCALE	
DE APPR.	AS	LONG BASKET LID ASSY (350)	NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

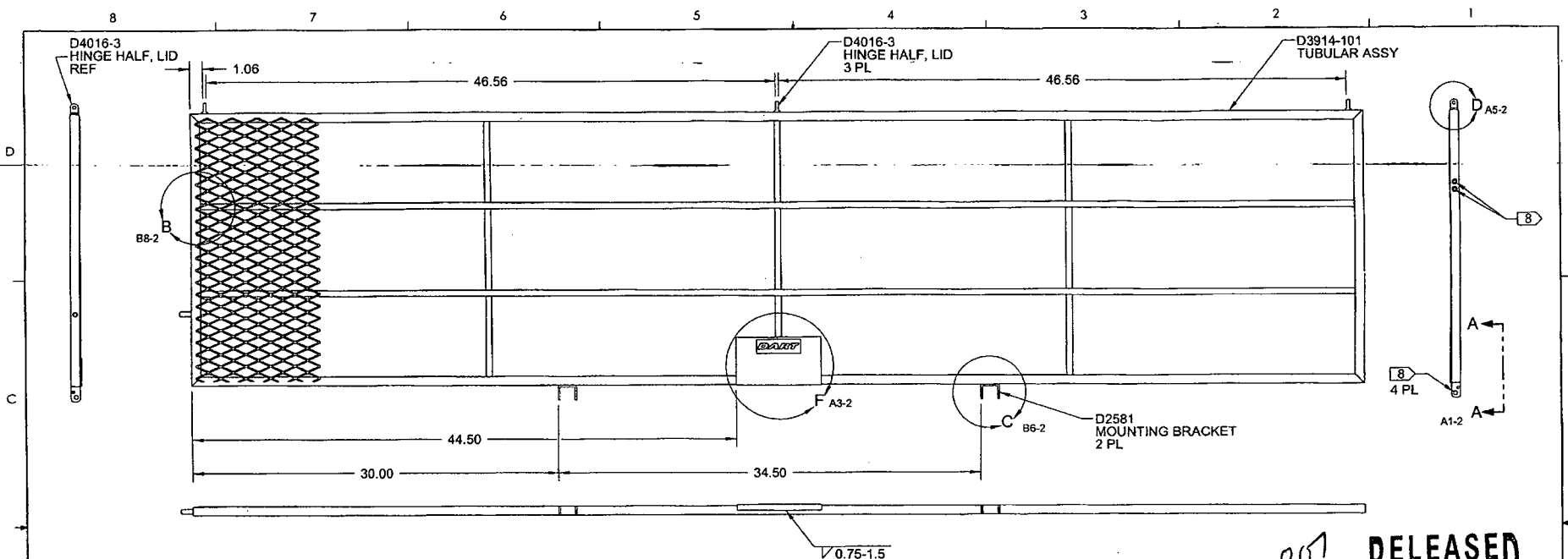
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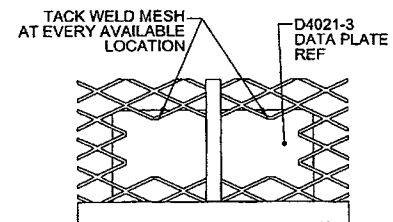
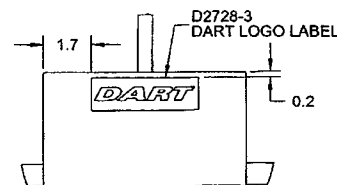
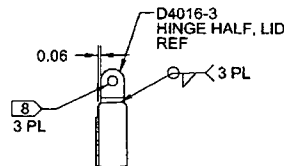
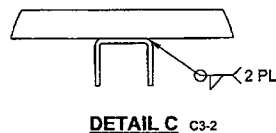
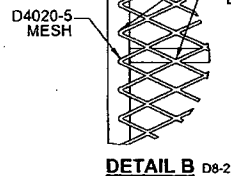
**NOTE:** Date & initial all entries



**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

# 73907 **RELEASED**  
10.08.05

TACK WELD MESH  
AT EVERY AVAILABLE  
LOCATION



**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MD	DRAWING NO.	REV. B
MFG. APPR.		D3914	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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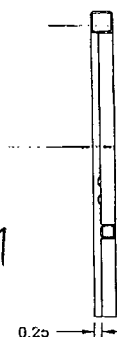
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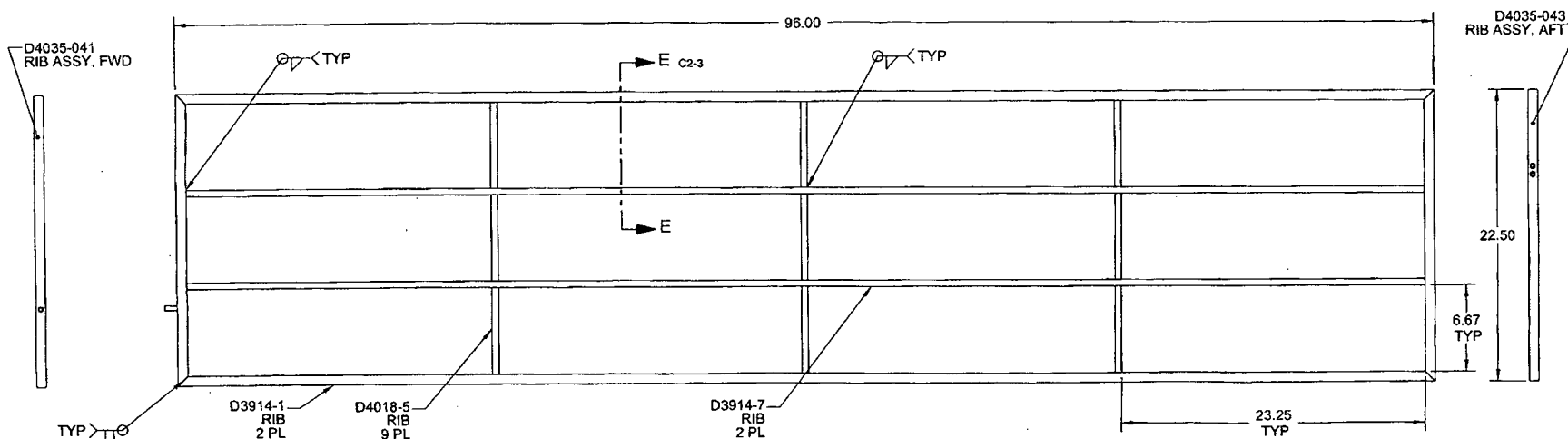


ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT

# 73907



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED  
10-08-12

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 14.10 lbs
  - 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4018-101
  - 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS	DRAWING NO.	REV. B
CHECKED	SC	D3914	SHEET 3 OF 4
MFG. APPR.	AS	TITLE	SCALE
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DE APPR.	AS	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
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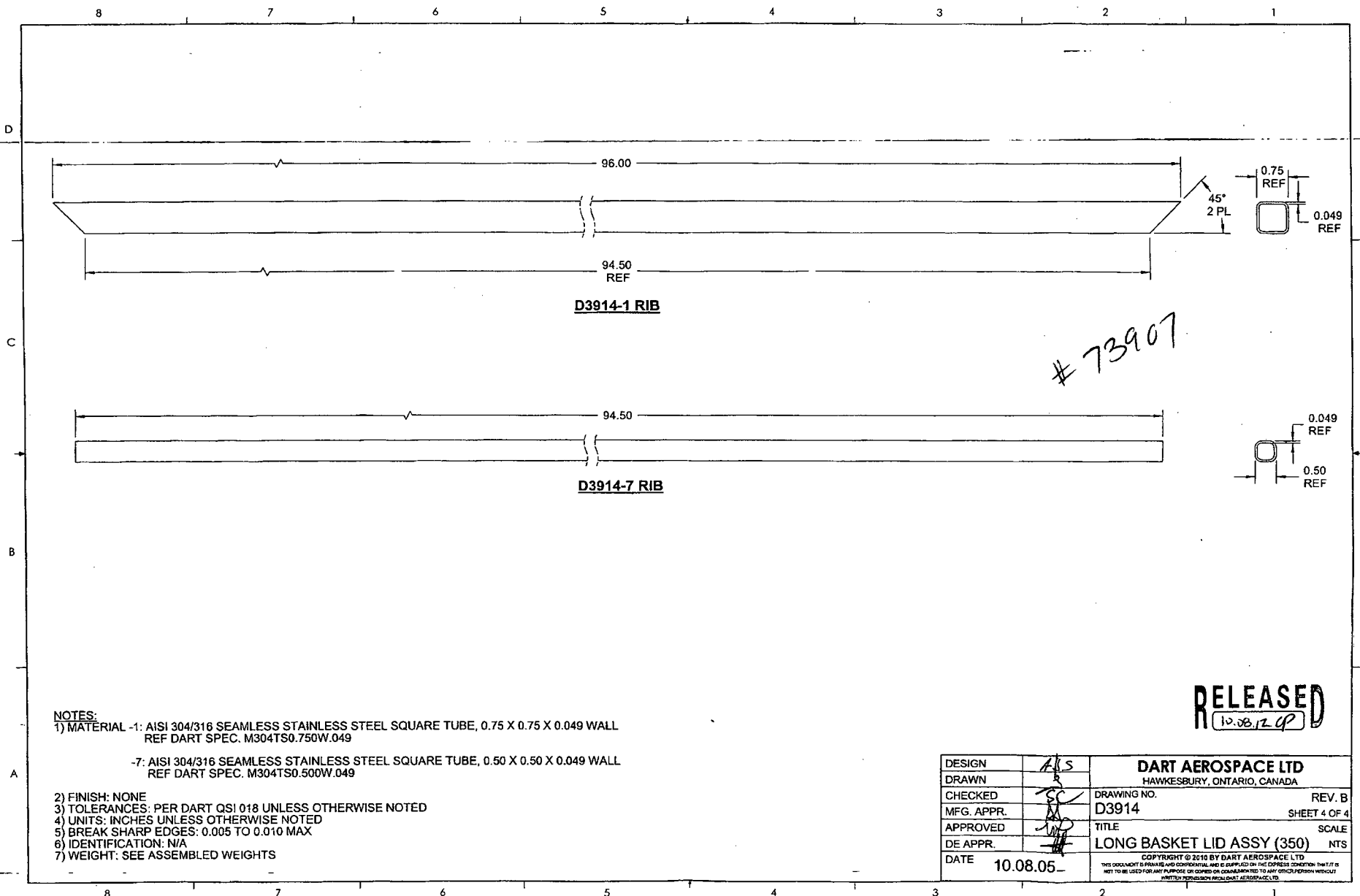
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